



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-021
Job Sheet 200549



Part No: D350-636-021

Job Qty: 1 pcs

Part Name: AS350/355 - Skidtubes - Standard w/ Standard Wearplates - LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 10/18/19

Description: SIOP

Type: Stock

Note: D2750-051 REV.H / IIN-D350-636 REV.K IPP REV:A 18.11.23 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Skidtubes - 1	1 pcs	10/18/19		0.00	4.55	Skidtubes - 1		DD
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	Skidtubes - 2 - B4B	1 pcs	10/18/19		0.00	4.55	Skidtubes - 1 - B4B		DD
						2.14	Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
						0.50	Skidtubes - 5 - B4B		BE
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
120	QC 10	1 pcs	10/18/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	10/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		

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DAS
68
9-89

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				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	OCT 24 2019 DAS 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140	Handfinish - 1-1 Chemical-B4B	1 pcs	10/18/19	0.00 0.93	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 - B4B
150	QC 7	1 pcs	10/18/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28

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				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	7C DO TF
160 Skidtubes - 3 - B4B	1 pcs	10/18/19	0.00 4.55 54min TF 24R 3E	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
170 QC 10	1 pcs	10/18/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
180 QC 5	1 pcs	10/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				DAS NOV 04 2019 68 9-89	
				DAS NOV 04 2019 68 9-89	
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				QC 5 - 81	
190 Handfinish - 2-1 Pressure-B4B	1 pcs	10/18/19	0.00 0.93	Handfinish - 2 - 1 - B4B	BE819-11-06
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	DAS 41 NOV 07 2019
200 Spray Paint - 2 - B4B	1 pcs	10/18/19	0.00 0.91	Spray Paint - 1 - B4B	9-89
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
205 Outsource - 10 - Consignment	1 pcs	10/18/19		ATE003-VC 5	NR
210 QC 14	1 pcs	10/18/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	BE819-11-08
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
230 Handfinish - 4-1-Assembly-B4B	1 pcs	10/18/19	0.00 0.93	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	BE819-11-08
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
240 QC 5	1 pcs	10/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				Plex 9/12/19 11:40 AM Dart.Renwick.Jennifer	

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				QC 4 - 75	M6 11/22/2019
270 Packaging 3-1 - Stock - B4B	1 pcs	10/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	M6 11/22/2019
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	10/18/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	DAS
280 QC 21 - FG	1 pcs	10/18/19	0.00 0.00	QC 21 - FG - 21	21
				QC 21 - FG - 70	21
				QC 21 - FG - 53	21

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg

Descriptions: D2750-5 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750 sheet 4 (D2750-5 details). Drill using drill Jig DT8150. 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6- Open up holes of Detail BF to 0.297" (total of 2 holes per side) and one 0.201" each side as per dwg 7- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 139011 8- Grind welds flush as per Dwg D2750

120 - (QC10- Inspect visual per QSI004- ground welds)

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7- Inspect Chemical Conversion Coat)

160 - 1- Open up holes using hole saw of Detail BG and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 4- Chamfer holes of Detail BG, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5-

Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 520625 exp. date: 07.25.20 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 15) A/R Aluminum Rod batch: 139011 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section CS-CS (total of 4 places per side) as per dwg D2750 12-Deburr holes, ensure tube is free of all scratches before sending to paint.

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***

190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5213125

210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-3, wearshoes and ground handling hardware as per dwg D2750 SIKAFLEX 241 BATCH: 5200625 EXP DATE: 2007 5- Coat all exposed fasteners with "LPS Procyon" batch: M133690

240 - (QC5- Inspect part completeness to step on W/O)

250 - Pick Kit)

260 - (QC4- 100% Inspect kits for completeness) *****ensure antiseize is on AN8C21A bolts*****

270 - (Identify as per dwg & Stock Location: FG108) Package as per PPP D350-636-021 Location : FG108

275 - record fwd angle: 89.9 Photocopy blue file and type labels per PPP D350-636-021 CHG 001

280 - (QC21- Final Inspection - Work Order Release)

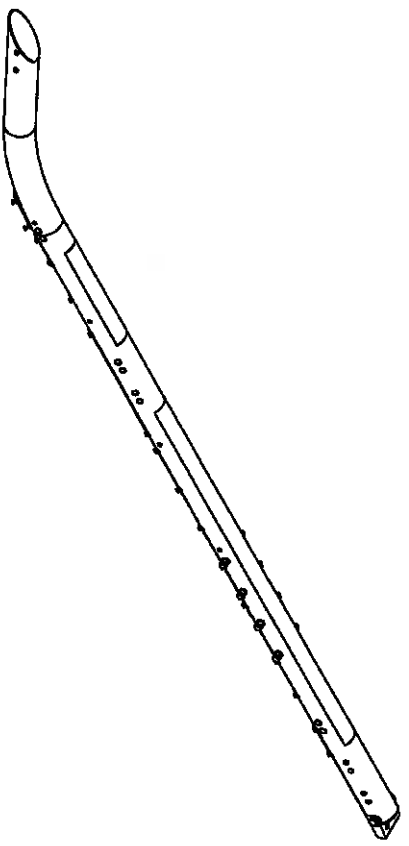
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	90-Skiddtubes - 1	<u>5216547</u>
D2744	Cap	1 pcs (1 ea)	110-Skiddtubes - 2 - B4B	<u>5192770</u>
D2739	350 I-Beam	1 pcs (1 ea)	160-Skiddtubes - 3 - B4B	<u>5221693</u>
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skiddtubes - 3 - B4B	<u>5214194</u>
AN3C5A	Bolt	34 Ea (34 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5123445</u>
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5049457</u>
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5222331</u>
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5221549</u>
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5219776</u>
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5215684</u>
D3537-1	Wearpad	3 pcs (3 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5225791</u>
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5184192</u>
D3791-1	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5219063</u>
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5210630</u>
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5219157</u>
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5216287</u>
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5215506-1</u>
NAS1149C0332R	Washer (AN960C10L)	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5218154</u>
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5076017-3</u>
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5214921</u>
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5214460</u>
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5186091</u>
D3793-5	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5210497</u>
MS21043-3	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5099569</u>
NAS1149C0363R	Washer (AN960C10)	2 Ea (2 ea)	230-Handfinish - 4-1-Assembly-B4B	<u>5135100</u>
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5100000</u>
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5210000</u>
MS21053C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5100000</u>
NAS1149D0303	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5100000</u>

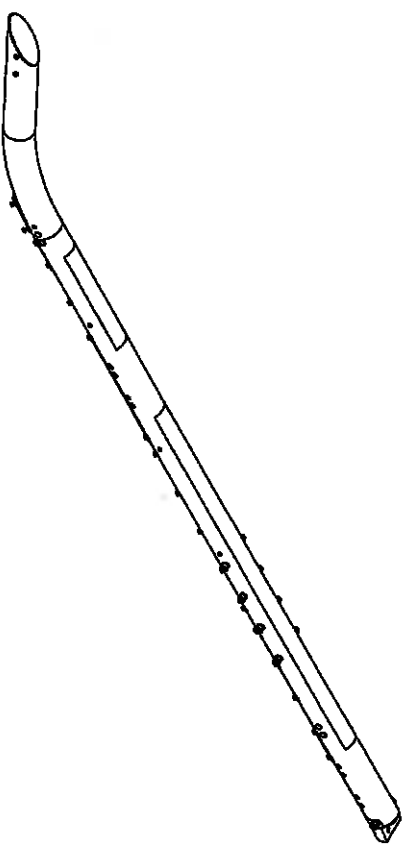
M.W. 012800

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Skidtubes - 1	D2600-3-BENT-LH	1	4	0
110-Skidtubes - 2 - B4B	D2744	1	38	0
160-Skidtubes - 3 - B4B	D2739	1	7	0
	D2743	8	143	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	38	854	0
	AN3C34A	1	33	0
	AN3C5A	34	689	0
	AN3C6A	4	95	0
	AN6C44A	4	60	0
	AN8C35A	1	13	0
	D2745	8	104	0
	D3488-3	1	18	0
	D3537-1	3	152	0
	D3631-1	8	256	0
	D3791-1	1	22	0
	D3793-1	1	30	0
	D3793-3	1	18	0
	D3793-5	1	27	0
	MS21043-3	1	665	0
	MS21043-6	4	74	0
	MS21083C8	1	45	0
	NAS1149C0332R	38	3,072	0
	NAS1149C0363R	2	549	0
	NAS1149C0832R	1	269	0
	NAS1515H3L	4	43	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	81	0
	D2741	1	65	0
	MS21083C8	2	45	0
	NAS1149D0863J	2	349	0
Part Specifications				
Specifications could not be found.				

Plex 9/12/19 11:40 AM Dart.Renwick.Jennifer



D2750-043 350 SKIDTUBE ASSEMBLY, LH



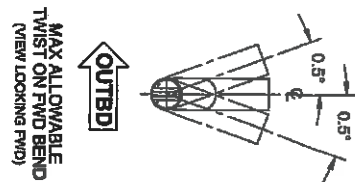
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2018 OCT 19

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.
DRAWN	ZF	EUGENE, OR
CHECKED	MM	
MFG. APPR.	DD	
APPROVED	NO	
DE APPR.	DS	
DATE	18.03.05	
TITLE		
350 SKIDTUBE ASSEMBLY		
SHEET 3 OF 16		
SCALE		
NTS		

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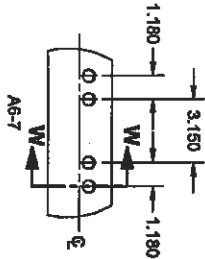
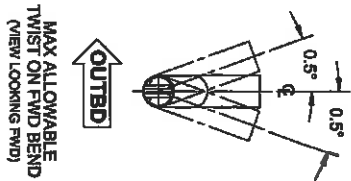
**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)**



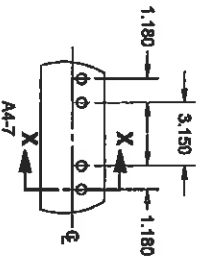
RECEIVED
2018 OCT 19

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DATE	18 02 96	

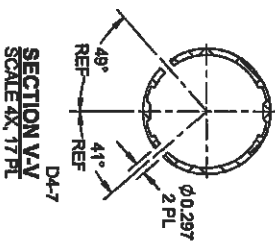
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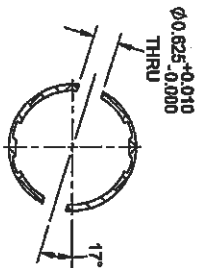
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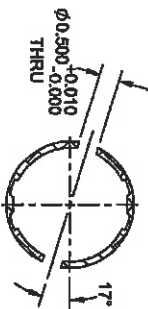
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D4-7
SECTION V-V
SCALE 4X, 17 PL



B6-7
SECTION W-W
SCALE 4X, 4 PL

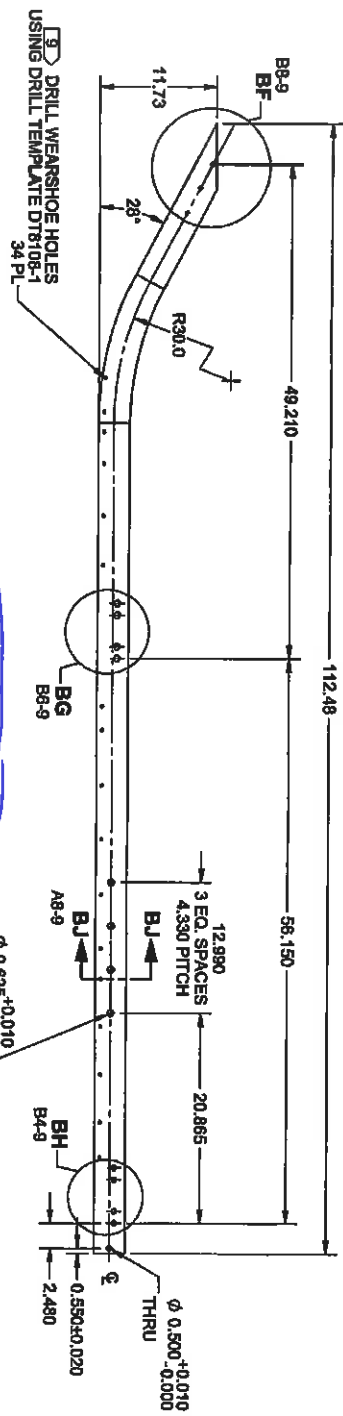


B4-7
SECTION X-X
SCALE 4X, 4 PL

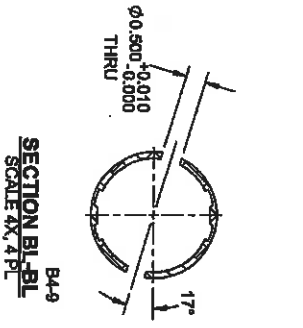
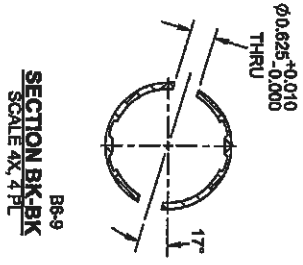
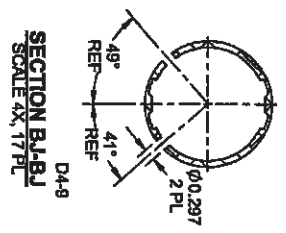
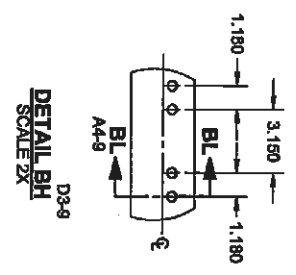
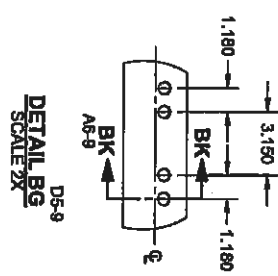
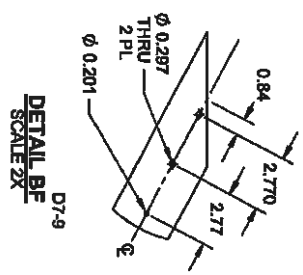
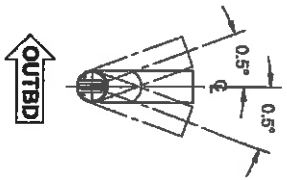
APPROVED

DESIGN		MMI	PART AEROSPACE USA, INC.	
DRAWING		ZF	ENGINEER, OR	
CHECKED		MMV	REV. H	
MFG. APPR.		DD	D2750	
APPROVED		NO	SHEET 7 OF 16	
DE APPR.		DS	SCALE	
DATE		18.03.05	360 SKIDTUBE ASSEMBLY	

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D2750-5 LH SKIDTUBE



DESIGN		MM	DART AEROSPACE USA, INC.	
DRAWN	ZF		EUGENE OR	
CHECKED	MM		REV. H	
ING. APPR.	DD		SHEET 8 OF 16	
APPROVED	NO		SCALE	
DATE	DS		NTS	
18.03.05			350 SKIDTUBE ASSEMBLY	

RELEASED
2018 OCT 19







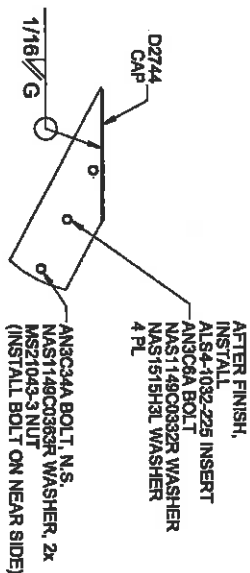
D2743
SPACER

TYP

WELDING INSTRUCTIONS:

- 1) CHAMFER HOLE TO 0.65 X .45°
- 2) INSERT D2743 SPACER (.0.625 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH
- 4) DRILL OUT SPACER TO Ø.484
- 5) SPOT FACE Ø0.750 (BOTH SIDES)

D8-15
DETAIL CQ
SCALE 2X



D2750-051 350 SKIDTUBE ASSEMBLY, LH

APPROVED		DART AEROSPACE USA, INC. ELIZABETH, OR	
DESIGN	MM	DRAWING NO. D2750 REV. H SHEET 16 OF 16 SCALE NTS	350 SKIDTUBE ASSEMBLY DATE 18.03.05
DRAWN	ZF		
CHECKED	MM		
INFG. APPL	DD		
APPROVED	NO		
DE APPL	DB	CAPABILITY © 1999 BY DART AEROSPACE USA, INC. ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING BY DART AEROSPACE USA, INC.	

FILED
2018 OCT 19 42

C4-15
SECTION C3-C5
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐				DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QS1042)							
Date: _____		Sequence #: _____		QTY Affected: _____													
Description Work Order Deviation						Disposition											
Completed By						Lead hand / Supervisor											
												QC / QA Coordinator					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____						Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					

5.0 PARTS LIST

D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 008 AND SUBSEQUENT

D350-636-021/-022 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
	X							D350-636-011	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
		X						D350-636-012	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
			X					D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
				X				D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
					X			D350-636-021	SKIDTUBE INSTALLATION, LH, STD
						X		D350-636-022	SKIDTUBE INSTALLATION, RH, STD
							X	D350-636-049	WEARSHOE KIT
1	1							D2750-041	SKIDTUBE ASSEMBLY, LH
1		1						D2750-042	SKIDTUBE ASSEMBLY, RH
1			1					D2750-043	SKIDTUBE ASSEMBLY, LH
1				1				D2750-044	SKIDTUBE ASSEMBLY, RH
1					1			D2750-051	SKIDTUBE ASSEMBLY, LH
1						1		D2750-052	SKIDTUBE ASSEMBLY, RH
*1	1							D2750-1	SKIDTUBE WELDMENT, LH
*1		1						D2750-2	SKIDTUBE WELDMENT, RH
*1			1					D2750-3	SKIDTUBE WELDMENT, LH
*1				1				D2750-4	SKIDTUBE WELDMENT, RH
1					1			D2750-5	SKIDTUBE WELDMENT, LH
1						1		D2750-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149C0832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
8	1		1		1			D3488-3	BLADE FITTING, LH
8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D3441	BLADE
10	2	2	2	2	2	2		AN6C44A	BOLT
11	2	2	2	2	2	2		NAS1149C0332R	WASHER
11C							8	D3672-1	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149C0332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER
*22	3	3	3	3	3	3	3	D3537-1	WEARPAD

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Revision: K

Date: 18.04.04

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
*22A	1	1	1	1	1	1	1	D3791-1	WEARPLATE
*23A	1	1	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*24A	1	1	1	1	1	1	1	D3793-5	WEARSHOE (REPLACES D3535-25)
*25A	1	1	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*26A	34	34	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	34	34	NAS1149C0332R	WASHER
*28	34	34	34	34	34	34	34	ALS4-1032-225	INSERT
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
50	2	2						D3532-1	SPACER
****g7					1	1		AN3C34A	BOLT
****g8					2	2		NAS1149C0363R	WASHER
****g9					1	1		MS21043-3	NUT
100A							4	AN526C1032R10	SCREW
100B							4	AN526C1032R18	SCREW

* PART OF D2750-041/-042, D2750-043/-044 OR D2750-051/-052 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

**** PART OF D2750-051 OR D2750-052 ASSEMBLY

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